



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB600N9904-1-1
Job Sheet 194844



Part No: RB600N9904-1-1

Job Qty: 4 pcs

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 5/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB600N9904-1 Rev.3 IPP Rev. A 19.01.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	HAAS 5 Axis	4 pcs	5/17/19	5/17/19	0.00	8.00	HAAS - 5	JS 19-05-16
110	QC 2	4 pcs	5/17/19	5/17/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	JS 19-05-16
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S181791



Part: RB600N9904-1-1

Job No: 194844

Serial No/Batch: S181791

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/16/19

120 QC 8	4 pcs	5/17/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	OK 19/05/21
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
125 Outsource - 4 - Anodize	4 pcs	5/17/19		GRO002-VC ATG001	OK 2019-05-22
126 Packaging 2-1 - Receive - B4B	4 pcs	5/17/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	OK MAY 29 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	

Plex 5/9/19 10:31 AM Dart.lajeunesse.marie

				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
127 QC 6	4 pcs	5/17/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	MAY 29 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
130 Packaging 3-1 - Stock - B4B	4 pcs	5/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	4 pcs	5/17/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 MAY 30 2019
Part Op 100 - ** CUT BLANK AT 8.100" ** 1-Machine as per folio FC757 FOLIO REV: <u>AA</u> DWG REV: <u>3</u> Descriptions: 2-Deburr <u>ATG</u> 125 - -Issue P/O: <u>43514</u> -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Material type; 6061T6 -Certificate of Conformity is required 126 - C of C required.					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R7.000	6061-T6 Round Bar 7.000"	2.7000 ft (.675 ea)	100-HAAS 5 Axis	S165 769	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 5 Axis	M6061T6R7.000	3	8	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 194.844
Description: Hoisting Adapter		Part Number: RB600N9904-1-1
Inspection Dwg: RB600N9904-1-1	Rev: 3	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.88	+/- .010	4.877	✓		Height gauge	
3.00	+/- .010	2.998	✓		SLIO Vern	
120°	+/- .5°	120°	✓		Protractor	
1.09	+/- .010	1.085	✓		SLIO Vern	
R.25	+/- .010	.250	✓		Rad gauge	
R.25	+/- .010	.250	✓			
3.00	+/- .010	3.000	✓			
6.33	+/- .010	6.330	✓			
60°	+/- .5°	60°	✓		Protractor	
Ø 1.50	+0.012/-0.001	1.500	✓		Protractor	
150°	+/- .5°	150°	✓		Protractor	
Ø .094	+0.004/-0.001	.095	✓			
R.25	+/- .010	.250	✓		Rad gauge	
.25	+/- .010	.252	✓			
2.81	+/- .010	2.808	✓			
1.63	+/- .010	1.626	✓			
.362	+/- .005	.358	✓			
.445	+/- .005	.447	✓			
.90	+/- .010	.900	✓			
Ø.250-.254	—	.250	✓		gauge Pin	
R.25	+/- .010	.250	✓			
135°	+/- .5°	135°	✓		Rad gauge	
5.313	+/- .005	5.308	✓		Protractor	
.69	+/- .010	.686	✓			
.03 X 45°	+/- .010 X .5°	.031	✓			
.312-.315	—	.312	✓		gauge Pin	
3.94	+/- .010	3.935	✓			
.681	+/- .010	.6804	✓			
R.25	+/- .010	.250	✓		Rad gauge	
.13 X 45°	+/- .010 X .5°	.130	✓			
					↓	
	DAS					

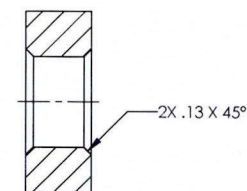
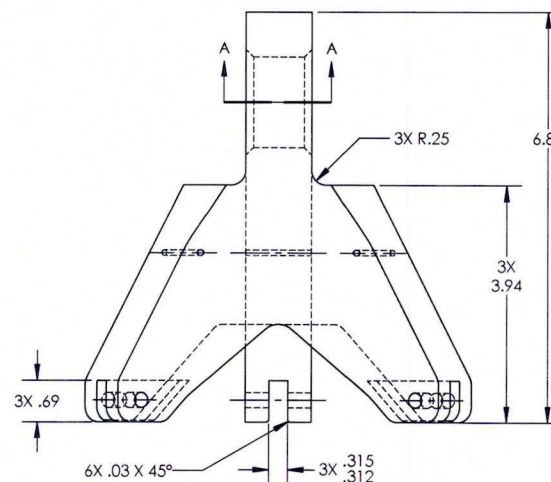
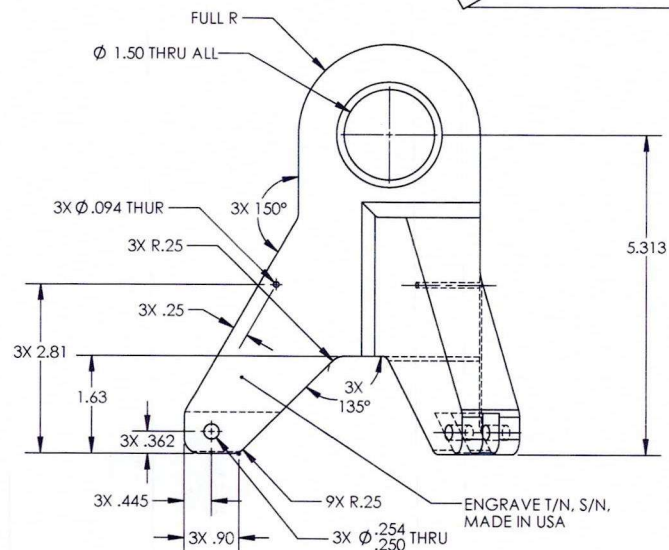
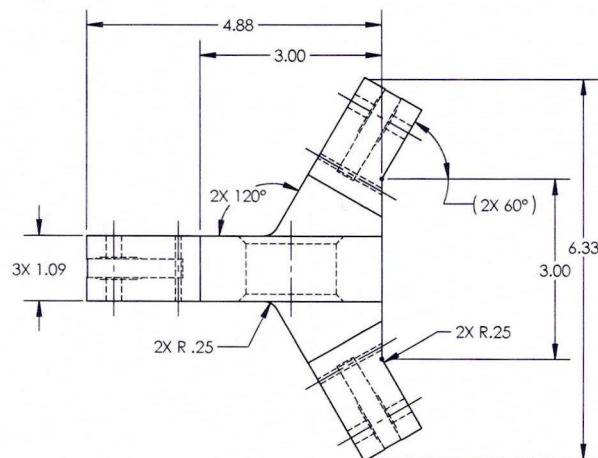
Measured by: 20 9-89	Checked by: [Signature]	QC Inspector:
Date: 19-05-15	Date: 19/05/21	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
A		-1 CHD PIN HOLE DISTANCE FROM .320 & ADDED OTHER DIMS.	12/18/2006	
1		-1 CHD TITLEBLOCK & REVISION BLOCK, CHD DIM FROM 3.938, CHD DIM FROM 2.813.	7/30/2009	RJC
2		-1 CHANGED ALL CORNER RADIUS CALL OUTS TO R.25 FROM .188 TO MATCH CNC PROGRAM.	6/28/2010	WP
3	15-0177	-1 MOVED .312 - .315 DIM, ADDED MISSING R.25 DIMS, CHD DIM WAS 3.000 IS 3.00, CHD NOTE WAS MARK P/N .125 TEXT IS ENGRAVE T/N, S/N, MADE IN USA.	7/22/2015	RJC



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194844 NW
190509

①
PLATE

DART AEROSPACE	
TITLE HOISTING ADAPTER	
DWG NO. RB600N9904-1-1	REV 3
MAT'L 6061	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	FINISH CLEAR ANODIZE
.XX ± .01	SPEC MIL-A-8625F, TYPE II, CLASS I
.X ± .1	USED ON MODEL MD600
1. BREAK ALL SHARP EDGES .015 x 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 8/3/2001
SHEET 2 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043514



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043514

PO Date: 5/22/19

Due Date: 5/29/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181929	644.4115	Bracket, Small Aft 1-ISSUE P/O TO ATG: _____ 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	5/29/19	46 pcs	0 pcs	46 pcs	\$8.00/pcs	\$368.00
2	181930	644.4116	Bracket, Small Fwd 1-ISSUE P/O TO ATG: _____ 2. Anodize Black - MPP-172 Section 2.1 - Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3. Certification of Conformity is required 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	5/29/19	27 pcs	0 pcs	27 pcs	\$8.00/pcs	\$216.00



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB043514



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	194844	RB600N9904-1-1	Plate -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	5/29/19	3 pcs	0 pcs	3 pcs	\$10.03/pcs	\$30.09
4	194443	C45-2-1	Sideplate - MRK Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	5/29/19	12 pcs	0 pcs	12 pcs	\$10.03/pcs	\$120.36
Grand Total:											\$734.45

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

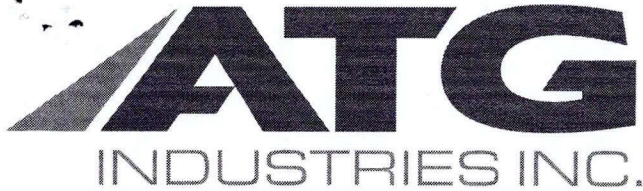
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/27/19 8:38 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917906

Date: 29-May-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
3 ea	Part: RB600N9904-1-1 Plate Anodize per MIL-A-8625F, Type II, Class 1, Clear, Water Sealant .0004-.0010" (4 - 1 mils) Job: 25177 PO: POHB043514	Rev: 3 Line: 3	DAS 68 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 29 2019</u> Certified Signature: <u></u> Receiver Signature: <u></u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			